

Work Order ID 120844

June-11-14 2:47:40 PM

120844

Page 1

Item ID: D3836-042

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Rib Assembly (Basket Lid, RH)

Start Date: 6/11/14 Start Qty: 8.00

~~*8*~~ 4x

Cust Item ID:

Required Date: 6/11/14 Req'd Qty: 8.00

~~*8*~~

Customer:

Reference:

Approvals:

Process Plan: MCJ

Date: 4-06-11

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3836

C

100

0.00

100

Large Fab

Large Fab

Memo

0.00

Large Fab

1- cut D3836-2 and D3836-3 rib as per dwg D3836 USE DT9827 TO TRACE D3836-3

2- remove identification markings

3- deburr

4- weld D3836-2 to D3836-3 and drill hole (3/16") using DT9447 jig and open to finish size as per dwg D3836

DAS
10
9-89

5- c/sink holes for 4021-9 bushings as per dwg

6- weld D2327-3 spacer bushing and bushings as per dwg D3836

A/R ER316 S.S. Rod Batch: 8123823

7- grind weld flush where indicated on dwg

4x CC 14-6-12

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Page 2

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Start Date: 6/11/14 Start Qty: 8.00

8

Cust Item ID:

Required Date: 6/11/14 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

QC9- Inspect visual per QSI004- Fusion Welds

0.00

130

QC

Memo

0.00

Quality Control

4x DAS 43 14-6-17
9-89

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

4x DAS 43 14-6-17
9-89

150

Identify as per dwg & Stock Location: W/A
004

0.00

150

Packaging

Memo

0.00

Packaging

4x CC 14-6-17

Work Order ID 120844

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Page 3

Item ID: D3836-042

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Rib Assembly (Basket Lid, RH)

Start Date: 6/11/14 Start Qty: 8.00

8

Cust Item ID:

Required Date: 6/11/14 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

MLJ 14-06-18

146.17

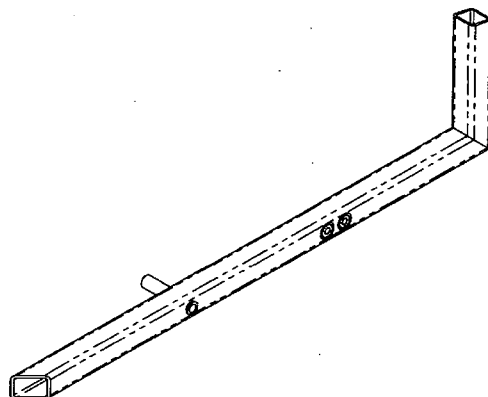
June-11-14 2:47:43 PM

120844

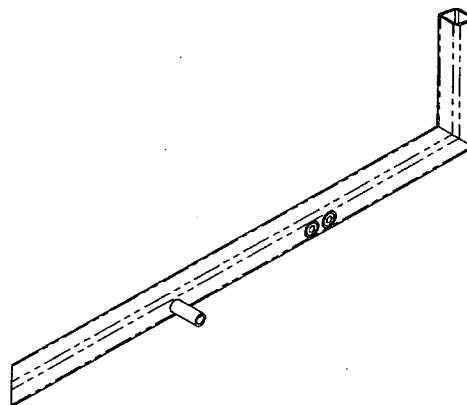
D3836-042

Required Qty: 8.00

600



D3836-042 RIB ASSY (BASKET LID, RH)



D3836-041 RIB ASSY (BASKET LID, LH)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.02 lbs EACH
- 8) WELD PER DART QSI 004

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
	X		D3836-041	RIB ASSY (BASKET LID, LH)
		X	D3836-042	RIB ASSY (BASKET LID, RH)
1	1	1	D2327-3	SPACER BUSHING
2	1		D3836-1	RIB
3		1	D3836-2	RIB
4	1	1	D3836-3	RIB
5	2	2	D4021-9	BUSHING



SEEK COPY
RETURN TO
FOR SPRING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITH NO NOTICE
WORK ORDER
NO. 120844 MJS

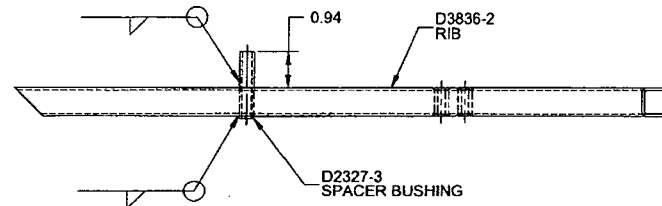
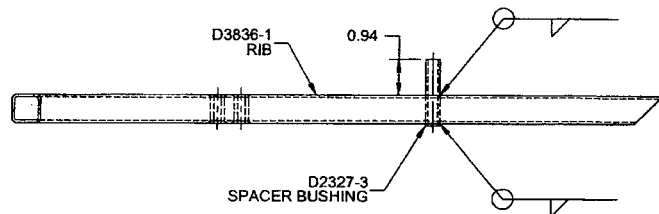
1406-11

RELEASED
2012-08-03
WJ

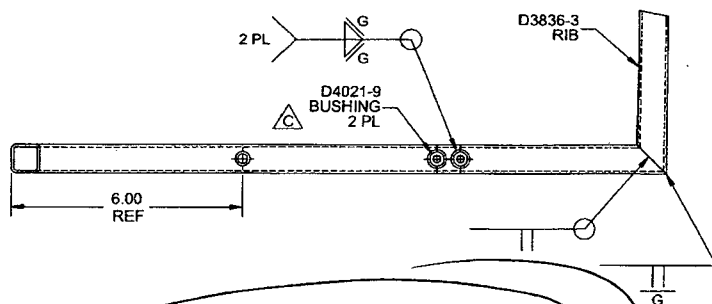
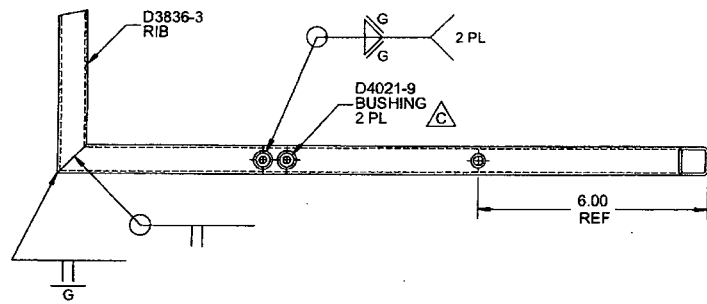
C	D4021-9 WAS D3759-1 (ZN D3-1) AND 11.05 WAS 11.673 (ZN B7-3 & C7-3). REASON FOR CHG: AN3 SIZE BOLTS REQ'D IN THOSE LOCATIONS AND CORRECTED DIM IAW FIG 9a OF D3550-607-1 REV. A.	MB	12.07.18
B	ADD QTY(2) D3759-1 BUSHING TO D3836-041/-042 (ZN D3-1, C6-2, C3-2, C6-3, C5-3, B6-3, B5-3). REASON: PART 10-50.	MB	12.05.11
A	NEW ISSUE	MB	08.09.24
REV.	DESCRIPTION	BY	DATE
DESIGN	1		
DRAWN	1		
CHECKED	AP		
MFG. APPR.	ES		
APPROVED	WJP		
DE APPR.	WJP		
DATE	12.07.18		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3836 TITLE RIB ASSY (BASKET LID) SCALE NTS SHEET 1 OF 3 REV. C COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR REPRODUCTION TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

8 7 6 5 4 3 2 1

D



C



B

D3836-041 RIB ASSY (BASKET LID, LH)

D3836-042 RIB ASSY (BASKET LID, RH)

A

8 7 6 5 4 3 2 1

RELEASE
2012-08-03

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3836	REV. C
MFG. APPR.		TITLE	SHEET 2 OF 3
APPROVED		RIB ASSY (BASKET LID)	SCALE
DE APPR.			NTS
DATE	12.07.18	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

0.75 X 45°
CHAMFER



$\varnothing 0.375^{+0.020}_{-0.000}$ THRU

$\varnothing 0.375^{+0.020}_{-0.000}$ THRU
 $\varnothing 0.49 \times 100^\circ$ CSINK
2 PL, ON BOTH SIDES

0.75 X 45°
CHAMFER

6.000

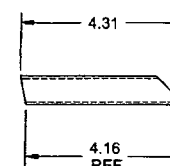
0.375

0.625

11.05

17.06

D3836-1 RIB



0.75 X 45°
CHAMFER

4.31

4.16
REF

D3836-3 RIB

0.75 X 45°
CHAMFER



$\varnothing 0.375^{+0.020}_{-0.000}$ THRU

$\varnothing 0.375^{+0.020}_{-0.000}$ THRU
 $\varnothing 0.49 \times 100^\circ$ CSINK
2 PL, ON BOTH SIDES

0.75 X 45°
CHAMFER

6.000

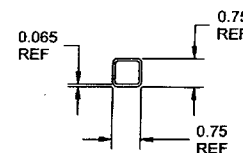
0.375

0.625

11.05

17.06

D3836-2 RIB



**TYPICAL SECTION
VIEW**

RELEASED
2012-08-03

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3836-1/-2 = 0.77 lbs EACH; D3836-3 = 0.19 lbs

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	<i>A.P.</i>	DRAWING NO. D3836
CHECKED	<i>A.P.</i>	REV. C
MFG. APPR.	<i>A.P.</i>	SHEET 3 OF 3
APPROVED	<i>A.P.</i>	SCALE
DE APPR.	<i>A.P.</i>	TITLE RIB ASSY (BASKET LID)
DATE	12-07-18	NTS

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